

Work Order ID 56189

February 12, 2010 10:37:25 AM



Page 1

Item ID: D3852-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 2/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *R*

Date: *10-2-12* Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

0.00

Memo

1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

SAP 10-02-23

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: *M109213*

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

(2)

PL 10-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

②

PD 10.03.01

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Swales/ly

②
-041

150

Identify as per dwg & Stock Location: bucket

0.00



Packaging

Memo

0.00

Packaging

②

PD 10.03.02

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03 *[Signature]*

B/cro-3-02

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NOTE: Date & initial all entries

Picklist Print

February 12, 2010 10:37:29 AM

Page 1

Work Order ID: 56189



Parent Item: D3852-041



Parent Item Name: Rib Assembly

Start Date: 2/12/10

Required Date: 2/18/10

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3166-3 Manufactured No

100

Each

14.0000

0.3789



Basket Hoop



SAD 10-02-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

48429

5

Main Warehouse

WA

9.000014474

52058

1.4474E-05

54018

3

55697

6

0.3789

D3759-1 Manufactured No

100

Each

36.0000

2.0000



Bushing



lpc 10-03-01

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

36

53442

2

54072

9

55789

25

* 2Cpl

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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB

D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56189

10-2-12

RELEASE
08/11/08 MP

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.83 lbs EACH
8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.		DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			DRAWING NO. REV. A
APPROVED			D3852 SHEET 1 OF 3
DE APPR.		TITLE SCALE	
		RIB ASSEMBLY NTS	
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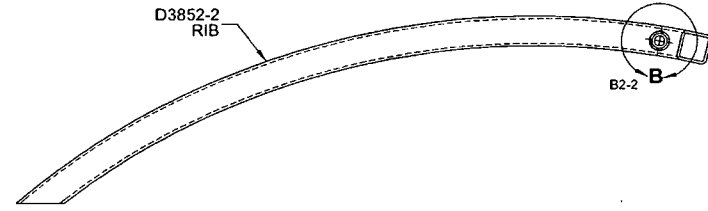
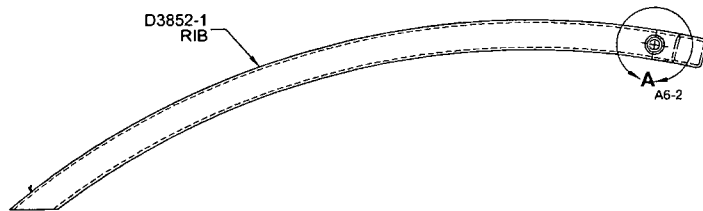
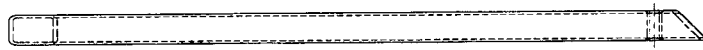
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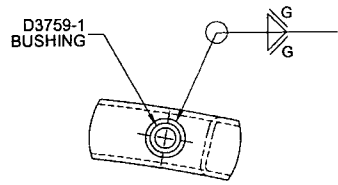
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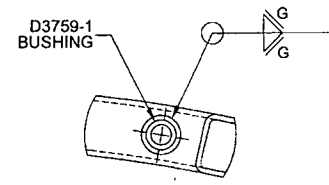


D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY



DETAIL A
SCALE 2X C5-2



DETAIL B
SCALE 2X C2-2

W/O 56189

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	125	DRAWING NO.	REV. A
MFG. APPR.	125	D3852	SHEET 2 OF 3
APPROVED	125	TITLE	SCALE
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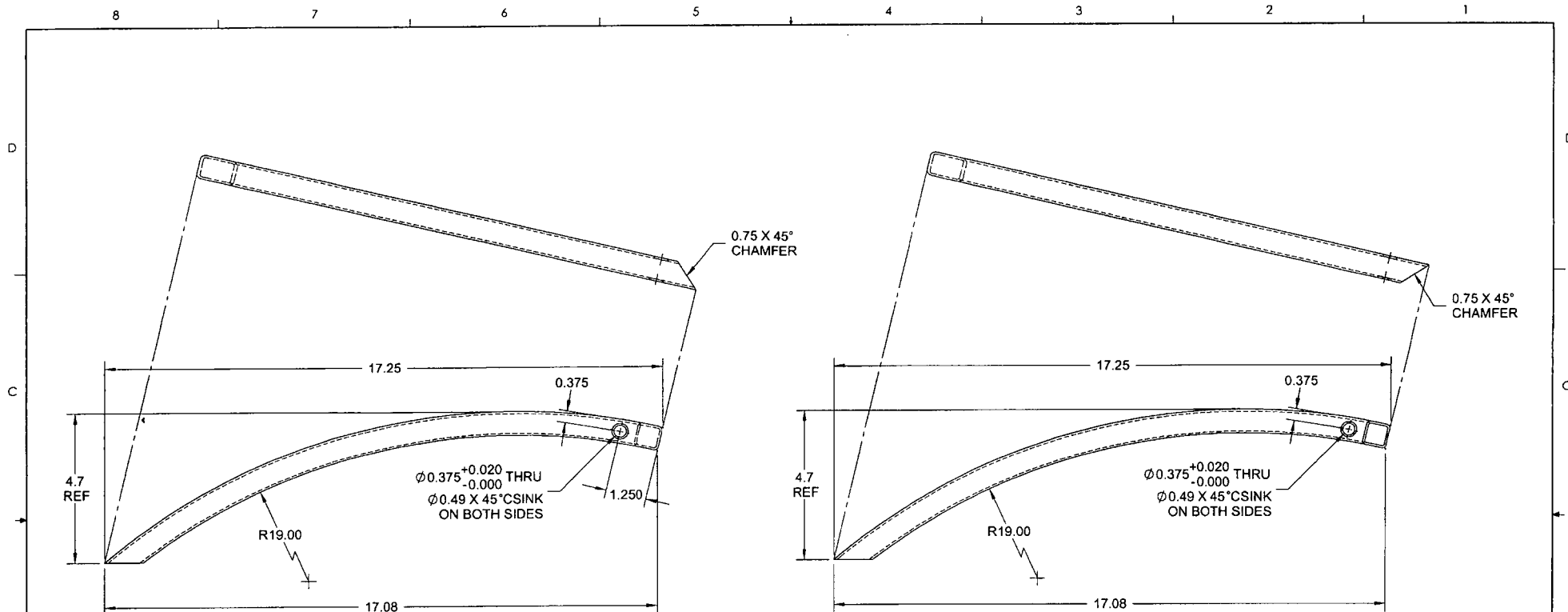
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NOTE: Date & initial all entries



D3852-1 RIB

D3852-2 RIB

W10 56189

RELEASED
08/11/07

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3852	SHEET 3 OF 3
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